

Shipping June 30th

Dart Aerospace Ltd.

Date: Monday, 6/12/2006 2:20:58 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 27536		
Estimate Number	: 10721		
P.O. Number	: NIA	Part Number	: D34637
This Issue	: 6/12/2006 S.O. No. : NIA	Drawing Number	: D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 25528	Material	: NIA
Written By	: <u>See Comment Below</u>	Due Date	: 6/19/2006 Qty: 4 Um: EACH
Checked & Approved By	: <u>06.06.12</u>		
Comment	: EST REV> A 05.11.18 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	Inventory
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Comment: Qty.: 1.0000 f(s)/Unit Total: 4.0000 f(s)
AISI 304 SS seamless tubing 0.750 OD X 0.120 wall
(M304TR0750W120)
Batch: 18452

FF 06.06.16

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Remove punch pins for hole, punch profile as per dwg D3463 using DT8313

2-Drill hole as per dwg D3463

3-Deburr

4-Bend end as per dwg D3463

FF 06.06.19

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

J.G 06/06/20

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1-Mill as per dwg D3463

2-Deburr

J.G 06/06/27
J.G 06/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:20:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27536

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

AS/3.606/06/27 06/06/20

4

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3D 06.06.27

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *US*

MA 06/06/27

(4)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/27

(4)

Job Completion



LC 06.06.27

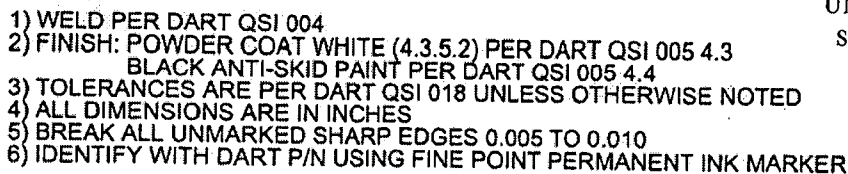
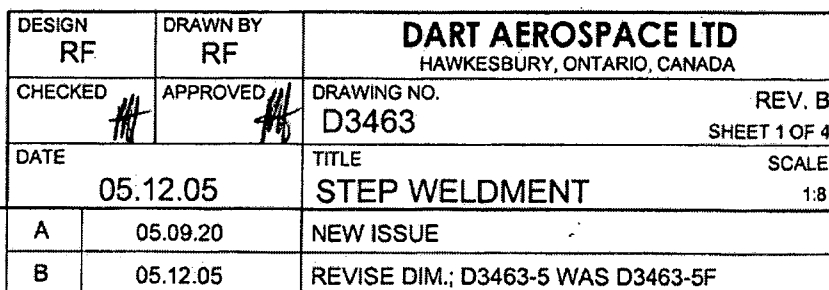
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



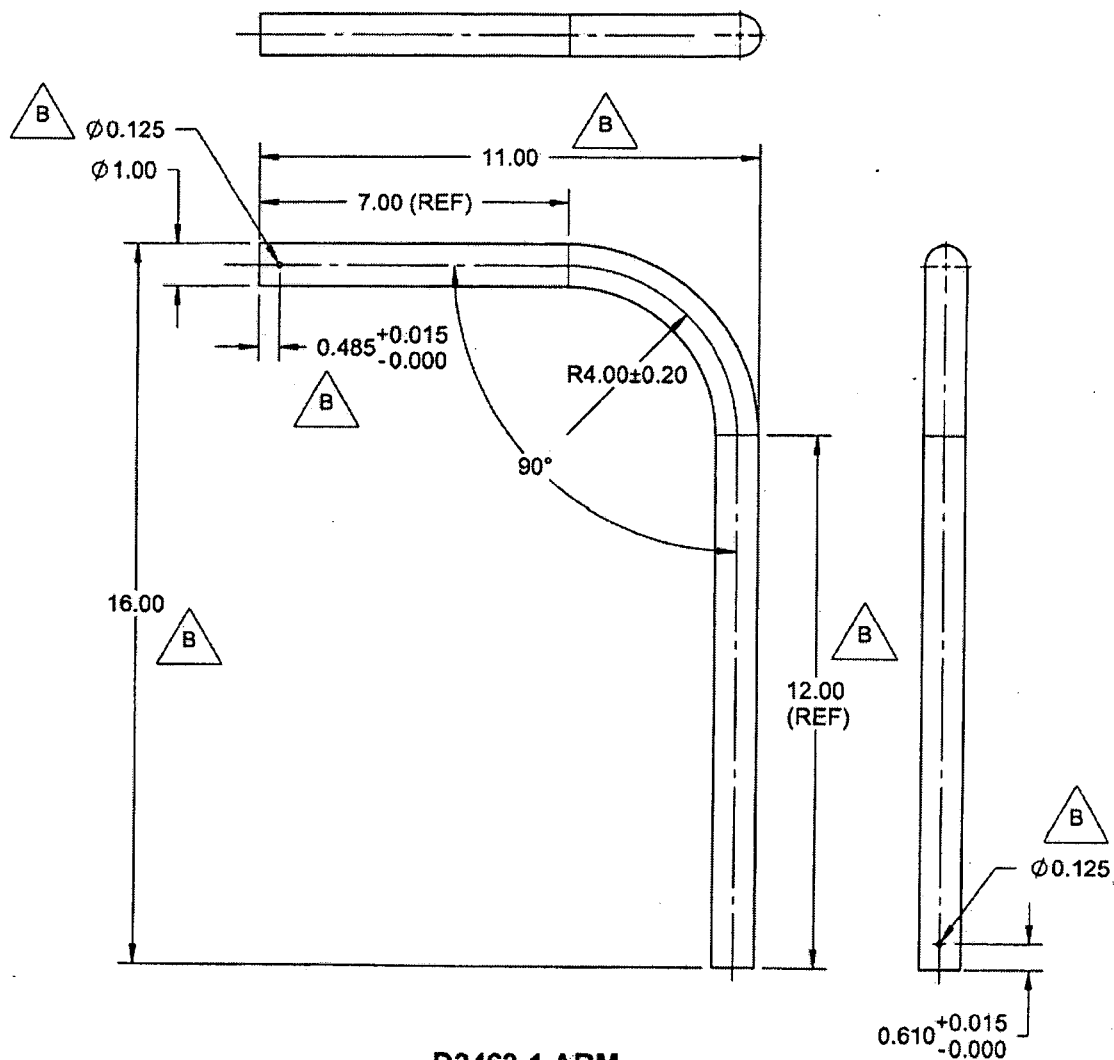
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WITHOUT NOTICE
WORK ORDER
NO. 27536

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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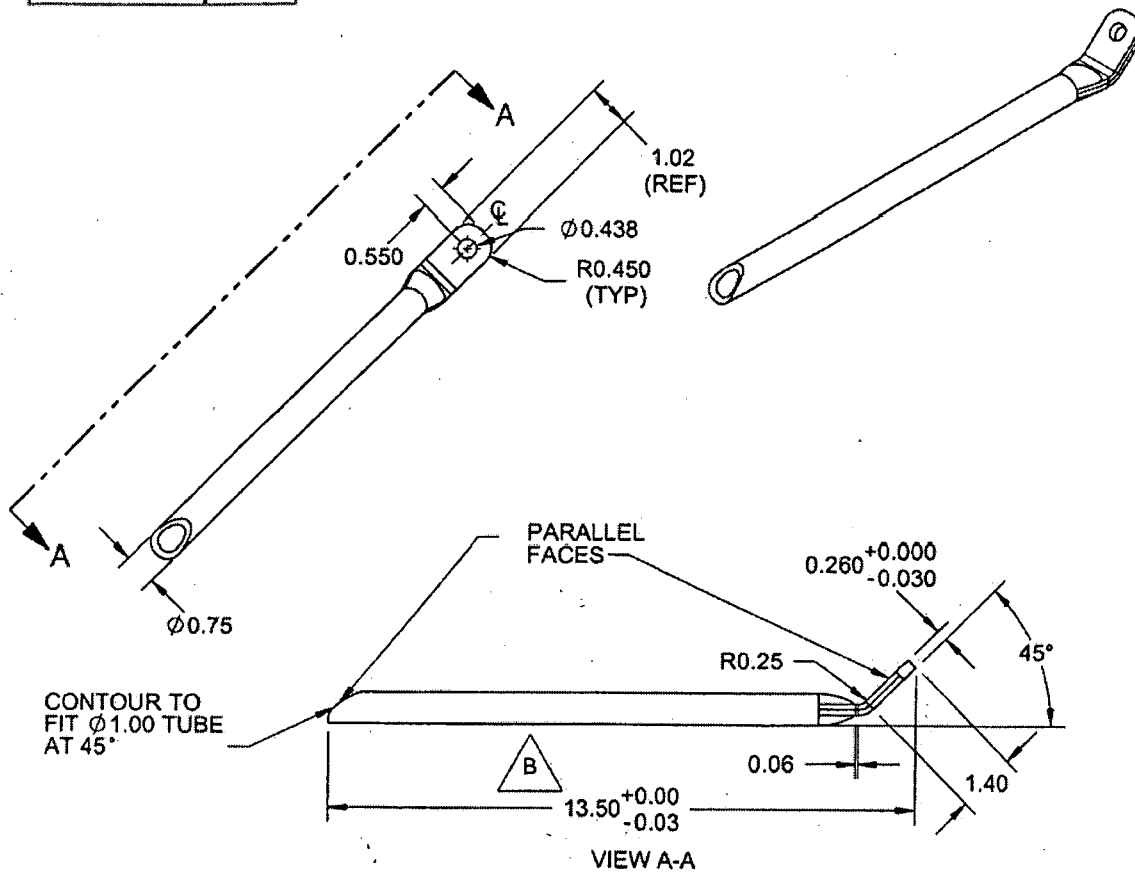
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WORK ORDER
NO. **27536**

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 #

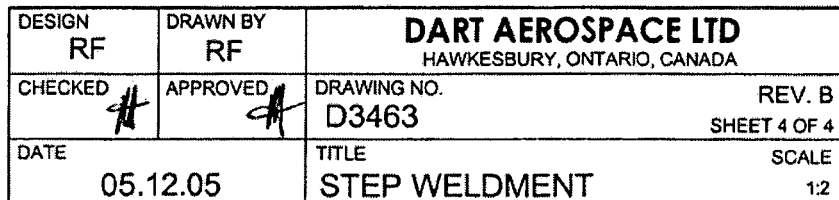
**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W1120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

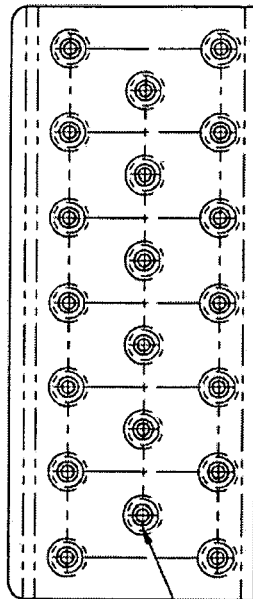
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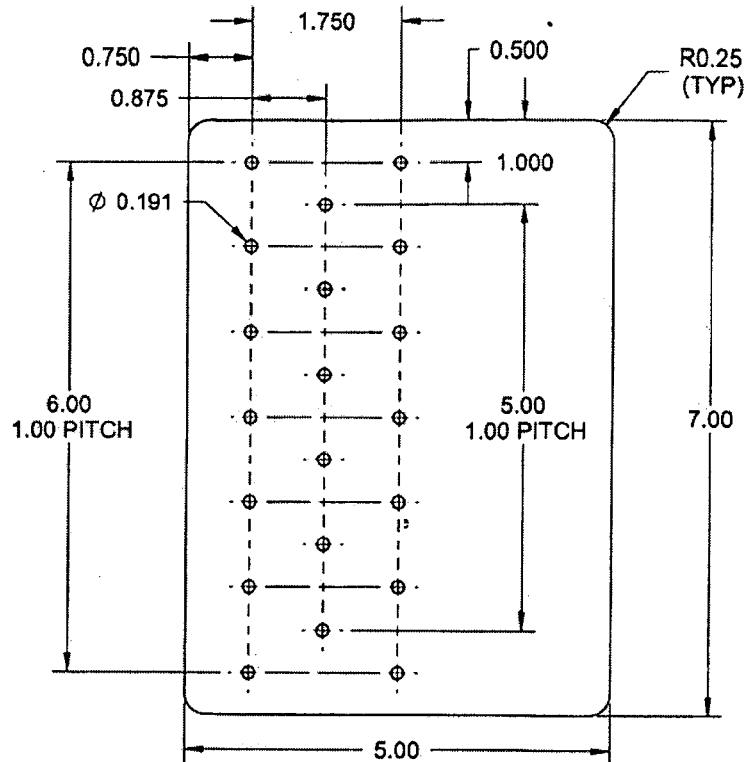
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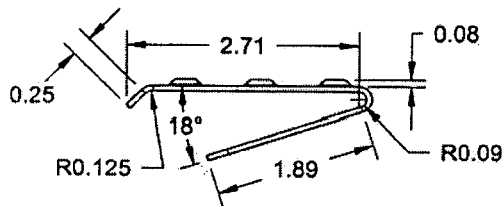
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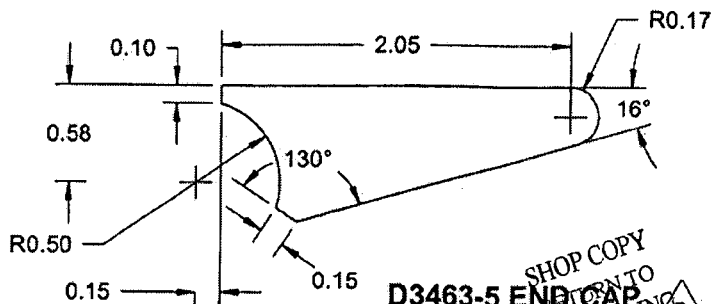
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



SHOP COPY
 D3462-5 END CAP
 SCALE 1:1
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 WITHOUT NOTICE
 WORK ORDER
 NO. 27536

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC.)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	27536
Description: STEP Weldment	Part Number:	D34637
Inspection Dwg: D3463, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


x

First Article

x

Prototype

[illegible]

Measured by: 	Audited by: J.F.	Prototype Approval:
Date: 06/06/27	Date: 06/06/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	